

AMENDMENTS TO THE SPECIFICATION

Please replace the paragraph beginning on line 19 of page 9 with the following amended paragraph:

Size press formulations were made using 80 pounds ethylated starch (Penford Gum-290) per ~~3300 square feet-ton~~ of paper per side of and two weights of calcium carbonate having a mean average size of 40 nm. The calcium carbonate weights were 20 pounds per ~~3300 square feet-ton~~ of paper per side and 40 pounds per ~~3300 square feet-ton~~ of paper per side. The formulations were applied to a paper substrate using a 2 roll size press.